

1 **Abstract**

2 This invention relates to a stabilized phenolic resole resin composition comprising a
3 phenolic resole resin and an effective stabilizing amount of an ortho ester. The invention
4 also relates to phenolic urethane binders prepared with the phenolic resole resin
5 compositions, and the use of the binders to make foundry mixes, foundry shapes, and
6 metal castings.